

Date: Thursday, 21/06/2007 2:57:31 PM
 User: Linda Lacelle

Process Sheet

SPLIT
07.10.31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW RING
 Job Number : 33099-2
 Estimate Number : 10396
 P.O. Number :
 This Issue : 21/06/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2968041
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2968
 Previous Run : 31957 Drawing Revision : B1
 Written By : W Material :
 Checked & Approved By : W Due Date : 10/07/2007 Qty: 3 Um: Each
 Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041

Batch: 102226

FL 07/06/23 20

2.0 D29681 Stem



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Stem 102302

FL 07/06/23 (20)

3.0 D29685 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Ring 102303

FL 07/06/23 (20)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/06/25 (20)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/06/25 (20)

6.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 4038

C Lottwood 25

Description: D2968-041 to heat treat to ultimate tensile strength

125ksi as per Dwg D2968

(20)

(20)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 33099

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Conformity sheet required

7/10: 5683 C208/02/12 (5)

Issue P/O: 4039

C207/06/25

Cad Plate per QQ-P-416F Class I Type II

(20)

Conformity sheet required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

10/3/3 (20)
07/04/25 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

00/03/13 (X5)
07/04/25 (20) *caution*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

M 107005 BR 08-03-17
105068

07/07/30 (20)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-A 08/03/17 (5X) (PTO)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 464

8/3/17 50 (5X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/20 (5)

Job Completion






u 08-03-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-31	10.0	After Powder coating, the cad plating is easily chipped off on 5 parts. see NCR 246	 05/10/2	Strip to remove Powder coat.	M-L 07/11/08 08-11-08		 05/10/2	 07-10-31

NOTE: Date & initial all entries

Placage

Manco Domplex

Electroplating

Siège social / Head Office	Plan 1
4660 Hickmore	4670 Hickmore
Ville St-Laurent, Québec	Ville St-Laurent, Québec
H4T 1K2	Fax: 514-355-5991
Fax: 514-355-8750	

Plan 2
8001 Larrey
Anjou, Québec
Fax: 514-354-2937

BON DE LIVRAISON
PACKING SLIP

Tél.: 514-355-7867 / 1-877-355-7867

V
E
N
D
U
À

EXPÉDIENT

DAVE ROSENBERG (TV)
1270 ARLINGTON ST
HAUNSBURY ONT K6A1

DATE DE COMMANDE ORDER DATE		DATE D'EXPÉDITION DATE SHIPPED		NO. DE COMMANDE P.O. NO.	
VIA		PRÉPARÉ PAR PREPARED BY		POUR INFO. CONTACTER	
N° DE COMM. P.O. NO.		DESCRIPTION		SPÉCIFICATIONS	
QUANTITÉ QUANTITY		UN		RÉSERVÉ RESERVED	
D2968-041 B33099		Yellow Cadmium .5		20	
D3028-1 B33369		Yellow Cadmium 25			
POIDS TOTAL TOTAL WEIGHT		REÇU PAR RECEIVED BY		TOTAL DE COLIS TOTAL PARCELS	
SIGNATURE					

AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY

COPIE BLANCHE / WHITE COPY: BUREAU / OFFICE - COPIE VERTE / GREEN COPY: CONFIRMATION D'EXPÉDITION / SHIPPING CONFIRMATION
COPIE ORANGE / ORANGE COPY: CLIENT / CUSTOMER - COPIE BLEU / BLUE COPY: FICHE D'EXPÉDITION / SHIPPING FILE

BON DE LIVRAISON
109405

MANCO DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1J6
Tél.: (514) 355-7867
Fax: (514) 355-8750

ATTN: CHANTAL - 1613-632 1053

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

#424

Dart Aerospace Ltd
Client / Customer

105683

Votre # de commande / Your purchase order #

1 Lot of fuses
de la pièce / part

109405

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Lemuel</u>	Date, équipe / Date, shift <u>Feb 28, 2008</u>
Placage / Plating <u>QCP 416 F CU TYPE II</u>	
Quantité totale / Total quantity <u>1 Lot</u>	Quantité inspectée / Inspected quantity <u>1 Lot</u>
Adhésion / Adhesion <u>Good</u>	
Épaisseur / Thickness L.C.D.	H.C.D. Moy. / aver. <u>0.0005</u>
Coussures, taches / Leach, spots <u>None</u>	Rugosité / Roughness <u>None</u>
Quantité approuvée / Approved quantity <u>1 Lot</u>	Quantité rejetée / Rejected quantity <u>—</u>

Commentaires / Comments

D2768-041 B333099 = 5 Pcs
D3008-1 B33369 = 25 Pcs

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

**MANCO
DOMPLEX**